

Date: Thursday, 3/2/2006 3:07:12 PM  
 User: Kim Johnston

## Process Sheet

13

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: VERTICAL REFERENCE DOOR 212/412		
Job Number	: 26024		Part Number	: D412711011		
Estimate Number	: 10887		Drawing Number	: N/A		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 3/2/2006	S.O. No. : <u>N/A</u>	Drawing Revision	: N/A		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: <u>N/A</u>		Due Date	: 3/30/2006 Qty: 1 Um: Each		
Previous Run	: 26023					
Written By	: <u>SAR</u> Comment Below.					
Checked & Approved By	: <u>ST</u> 06.03.02					
Comment	: Est Rev:A 04.09.29 New issue KJ/JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :			
1.0	DC	DOCUMENT CONTROL			
<b>Comment:</b> DOCUMENT CONTROL Photocopy bluefiles and create labels per PPP D412-711-011 CHG001 <u>DT : 06/03/06</u>					
2.0	PACKAGING 1	PACKAGING RESOURCE #1			
<b>Comment:</b> PACKAGING RESOURCE #1 Pick Packing Kit <u>06.03.03</u>					
3.0	D412711041	Vertical Ref. Door Assy			
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 1 D412-711-041 Vertical Reference Door <u>25600</u>					
4.0	D412711111	Wiring Harness, 212/412			
<b>Comment:</b> Qty.: 1.0000 Eagle(s)/Unit Total : 1.0000 Eagle(s) Pick: Packing Kit Qty Part Number Description Batch 1 D412-711-111 Wiring Harness, 212/412 <u>B21801</u> ✓					
5.0	EA2046915412	Instrument Panel, 412			
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 1 EA20469-15-412 Instrument Panel, 212/412 <u>M19150</u> ✓					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/03/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/2/2006 3:07:12 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR 212/412

Job Number: 26024

Part Number: D412711011

Job Number:



Pa 6/3/13

Seq. #: Machine Or Operation:

Description :

6.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

C 206/03/13

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-711-011

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

Co 6/3/13.

8.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/03/13

Job Completion



U 06/03/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/30/2006 3:43:53 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: VERTICAL REFFERENCE DOOR ASSEMBLY		
Job Number	: 25669					
Estimate Number	: 10902					
P.O. Number	: N/A			Part Number	: D412711041	
This Issue	: 1/30/2006		S.O. No. : N/A	Drawing Number	: N/A	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A		Type : PURCHASED PARTS	Drawing Revision	: N/A	
Previous Run	: 21476			Material	: N/A	
Written By	: See COMMENT Below			Due Date	: 2/20/2006	
Checked & Approved By	: <u>KJ/06.01.30</u>			Qty:	1 Um: Each	
Comment	: Est Rev:A 04.08.18 New Issue KJ/DS					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
2.0	OUTSIDE SERVICE	OUTSIDE SERVICES

Comment: Sub-Contracting OUTSIDE SERVICES

## EAGLE

Pick:Qty Part Number Description Batch  
 1 204-030-853-119 LH Co-pilot Door \_\_\_\_\_  
 Attach serviceable tags

*Call ZHache*

## 2- EAGLE

Fabricate/Pick the following parts to go into the door in accordance with:

D2046902 Sheet

1 Rev. 3

D2046902 Sheet 2 Rev. 2

D2046902 Sheet 3 Rev. 0

D2046901 Sheet 3 Rev. 1

Qty Part Number Description Batch

1	EB212-100L / EA20469-3	Window	_____
1	EA20469-05	Rubber Strip	_____
1	EA20469-06	Aluminum Strip	_____
1	EA20469-07	Angle	_____
1	EA20469-08	Placard	_____
1	EA20469-10	Rear Rib Assy	_____
1	EA20469-11	Angle	_____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/30/2006 3:43:54 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 25669

Part Number: D412711041

Job Number:



Seq. #:	Machine Or Operation:	Description :
1	EA20469-12	Fwd Rib
1	EA20469-13	Window
1	EA20469-14	Window Retainer
1	EA20469-16	Armrest Assy
1	EA20469-17	Angle
1	EA20469-18	Door Inner Skin
1	EA20469-21	Door Cover Panel
2	EA20469-23	Link
1	EA20469-24	Rod
1	EA20469-25	Arm Assy

Material Certification / Proof of Traceability / Certificate of Conformity required

3-EAGLE

Pick:

Qty	Part Number	Description	Batch
14	AN3-3ABolt		
22	AN3-4ABolt		
24	AN3-7ABolt		
6	AN960-6L Washer		
90	AN960-10L Washer		
34	CR3242-4-2 Rivet		
135	MS20426AD3-3 Rivet		
140	MS20426AD4-3 Rivet		
25	MS20470AD3-3 Rivet		
90	MS20470AD4-3 Rivet		
24	MS21042L3 Nut		
2	MS21042L06 Nut		
13	MS21069L3 Nut Plate		
8	MS21069L08 Nut Plate		
1	MS21071L3 Nut Plate		
1	MS21071L08 Nut Plate		
9	MS21075L3 Nut Plate		
2	MS24677-12 Screw		
6	MS27039-1-09 Screw		

4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 5Do not install EA20469-15 or wiring harness at this time.

5-Apply Dart P/N & B/N using fine point permanent marker

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/30/2006 3:43:54 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFFERENCE DOOR ASSEMBLY

Job Number: 25669

Part Number: D412711041

Job Number:



Seq. #: Machine Or Operation:

Description :

3.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS

Send this W/O back to DartKit to be stocked at Eagle

4.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

5.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/03/02  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd.

Date: Friday, 23/2/2006 23:02:11 PM  
User: Linda Lassle

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: VERTICAL REFERENCE DOOR ASSEMBLY		
Job Number	25669	Part Number	: D412711041		
Estimate Number	10902	Drawing Number	: N/A		
P.O Number	:	Project Number	: N/A		
Thru Issue	: 2/3/2006	S.O. No.	:		
Print Rev.	: NC	Drawing Revision	: N/A		
First Issue	: 1/30/2006	Type	: PURCHASED PARTS		
Previous Run	: 21476	Material	: N/A		
Written By	:	Due Date	: 2/20/2006		
Checked & Approved By	:	Qty:	1		
Comment	: Est Rev:A D4.08.18 New Issue KJ/LJS	Unit:	Each		

Additional Product:

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	PG	PURCHASING
<b>Comment: PURCHASING</b> Issue P/O: _____ to Eagle Copters "Assembly of D412-711-041 Door Assembly in accordance with Dart IPP D412-711-D41" Send a copy of this IPP		
2.0 OUTSIDE SERVICE		
<b>Comment: Sub-Contracting OUTSIDE SERVICES</b>		

## EAGLE

Pick Qty Part Number Description Batch  
 1 204-030-853-119 LH Co-pilot Door 1/6 40359  
 Attach serviceable tags

## 2- EAGLE

Fabricate/Pick the following parts to go into the door in accordance with:

D2046902 Sheet

- 1 Rev. 3
- D2046902 Sheet 2 Rev. 2
- D2046902 Sheet 3 Rev. 0
- D2046901 Sheet 3 Rev. 1

Qty	Part Number	Description	Batch
1	EB212-100L / EA2D469-3	Window	<u>30473</u>
1	EA2D469-05	Rubber Strip	_____
1	EA2D469-06	Aluminum Strip	_____
1	EA2D469-07	Angle	<u>N/A</u>
1	EA2D469-08	Placard	_____
1	EA2D469-10	Rear Rib Assy	_____
1	EA2D469-11	Angle	_____

 } 1/6 40359

02/27/2006 15:03 6136321053 DART AEROS

PAGE 03

Date: Friday, 2/27/2006 2:30:01 PM  
User: Linda Latelle

## Process Sheet

Customer: CL-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 25660

Part Number: D412711041

Job Number:



Seq. #:	Machine Or Operation:	Description :
1	EA20469-12	Front Rib
1	EA20469-13	Window
1	EA20469-14	Window Retainer
1	EA20469-16	Armrest Assy
1	EA20469-17	Angle
1	EA20469-18	Door Inner Skin
1	EA20469-21	Door Cover Panel
2	EA20469-23	Link
1	EA20469-24	Rod
1	EA20469-25	Arm Assy

W/0 40359

Material Certification / Proof of Traceability / Certificate of Conformity required

## 3-EAGLE

PICK:

Qty	Part Number	Description	Batch
14	AN3-3ABolt		07196
22	AN3-4ABolt		59575
24	AN3-7ABolt		17597
6	AN960-4L Washer		13051
90	AN960-10L Washer		57511
34	CR3242-4-3 Rivet		59327/625-216
136	MS20428AD3-3 Rivet		50331
140	MS20428AD4-3 Rivet		50331
25	MS20470AD3-3 Rivet		52175
50	MS20470AD4-3 Rivet		52175
24	MS21042L3 Nut		59485
2	MS21042L08 Nut		53447
13	MS21089L3 Nut Plate		024567
8	MS21089L08 Nut Plate		019155
1	MS21071L3 Nut Plate		024567
1	MS21071L08 Nut Plate		55874
9	MS21075L3 Nut Plate		04769
2	MS24077-12 Screw		11931
6	MS27039-1-09 Screw		15766

4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 0 Do not install  
EA20469-15 or wiring harness at this time.

5-Apply Dart P/N & B/N using line point permanent marker Ref PO- 001636.7

02/27/2006 16:03 6136321953 DART:AEROSPACE PAGE 004

Date: Friday, 23/2/2006 23:01 PM  
User: Linda Locella

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 25669

Part Number: D412711041

Job Number:



Seq. #: Machine Or Operation:

Description:

3.0 QC4

INSPECT 100% KITS FOR COMPLETENESS

*J. Koch*

Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS

Send this W/O back to Dartkit to be stocked at Eagle

4.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

6.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*DD 06/03/02*

Job Completion

*U 06/03/02*